

Work Order ID 65050-2



Page 1

Friday, April 08, 2011 8:26:11 AM

Item ID: D2230-3

Revision ID:

Item Name: Lug

Start Date: 1/5/2011

Start Qty: 100.00

Required Date: 1/14/2011

Req'd Qty: 100.00

Reference:

Approvals:

Process Plan: *CL*

Date: *11/04/08*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

0.00

0.00

0.00

0.00

BAND SAW

Memo

Cut D2423 extrusion to 0.82"

Batch:

cut extrusion @ meter

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FA927

FOLIO REV:

DWG REV:

Check for crack while loading into the machine.

2- deburr

issue Pro formeter P/O: 13833

*Machine as per drawing D2230
REV.G*

CL 11/04/08 (100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65050

Friday, April 08, 2011 8:26:11 AM



Page 2

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 1/5/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC
Quality Control

QC2 Inspect parts off machine EA/FAIR

0.00

Memo

0.00

*Rec'd + inspect for transit damage -
attached C of C to W/O*

1/4/4/20 25

130



QC
Quality Control

QC6 Inspect parts - second check

0.00

Memo

0.00

Sulorbe

*count
X25*

150



HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4 I

0.00

Memo

0.00

25 BK 11-4-27.

Work Order ID 65050

Friday, April 08, 2011 8:26:11 AM



Page 3

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 1/5/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

25 ~~0~~ m-l 11/05/09

170

White Gloss(Ref:4.3 5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:10

OVEN TEMPERATURE: 320 °F

FINISH TIME: 10:40

25 ~~0~~ m-l 11/05/09

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

25 ~~0~~ m-l 11/05/09

M116964

Work Order ID 65050

Friday, April 08, 2011 8:26:11 AM



Page 4

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 1/5/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location. 476

0 00



Packaging

Memo

0 00

Packaging

11/5/11 SP (250)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0 00

Quality Control

11/5/11 SP

W 11-05-10

Picklist Print

Friday, April 08, 2011 8:26:07 AM

Page 1

Work Order ID: 65050

Parent Item: D2230-3

Parent Item Name: Lug



Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP ☐ D00.05.18: Added inspection level 8, and removed P/O for powder coat ☐ EC
25 JLM VERIFIED BY:EC
IPP REV :E NEW FOLIO # 10-05-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 		Manufactured	No			100	r	377.3100	0.0683	7.189474			
Lug Extrusion													

C211104108

Location	Loc Qty	Loc Code
MAT006	377.31	
43722	161.5	
45800	1	
63005	214.81	

719

D2230-3P

X100

[Handwritten signature]

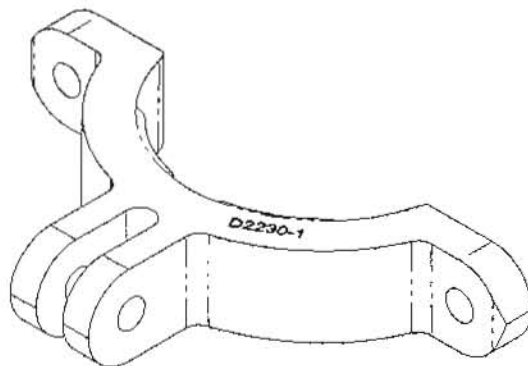
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

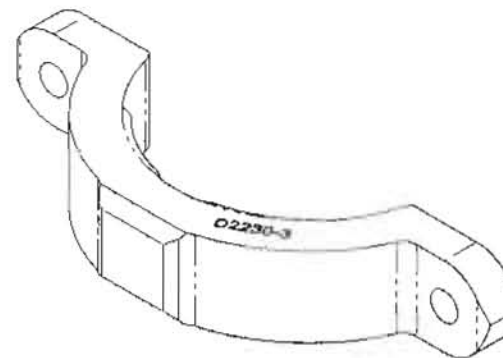
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
CP/BSH/SM

CL 11/04/08
W/D: 65050



NOTES:

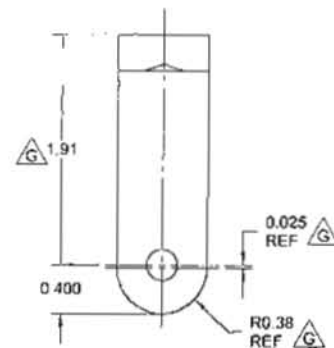
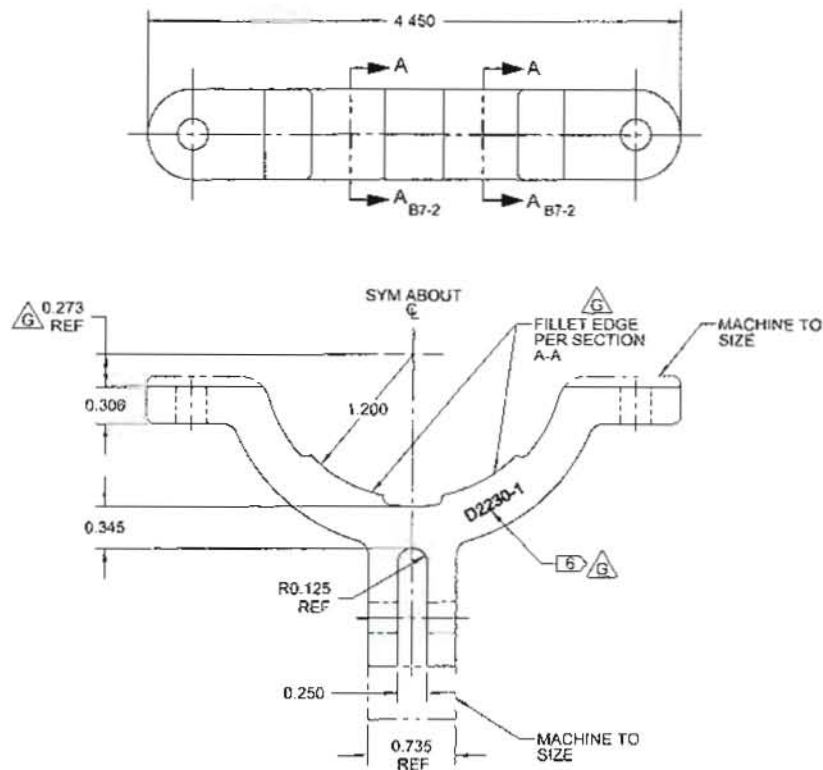
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES, 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

DESIGN	BW	DART AEROSPACE LTD	REV G
DRAWN	AJS	MAWESBURY, ONTARIO, CANADA	SHEET 1 OF 3
CHECKED		DRAWING NO	
MFG. APPR		D2230	
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD	

SECTION A-A 04-2
SCALE 2X







R0.06 MIN - R0.10 MAX
2 PL



D2230-1 MOUNTING LUG

W10.65050

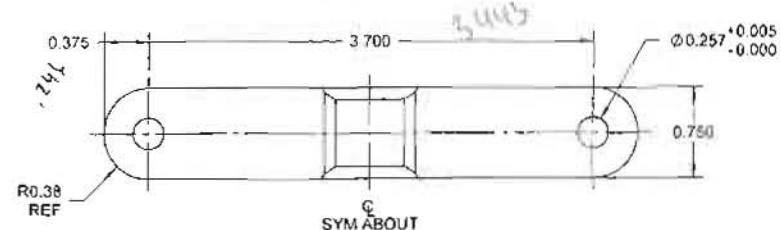
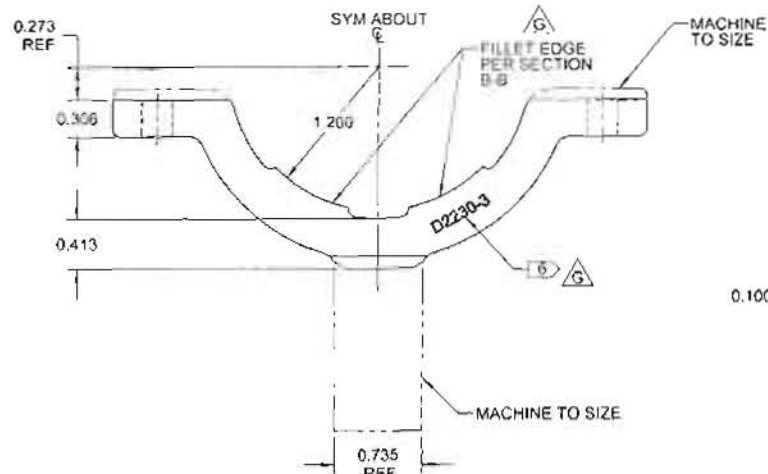
RELEASED
09/06/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. G
MFG. APPR		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
To a 300mm x 450mm x 10mm plate, unless otherwise specified, and is subject to the express condition that it is not to be used for any purpose or equipment without the express written consent of Dart Aerospace Ltd.			

SECTION B-B
SCALE 2X



R0.08 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/2016

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAMPSHIRE, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. G
MFG APPR		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	N/A
DATE	09.01.16	COPYRIGHT © 1999 BY DART AEROSPACE LTD	

W10.65050



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13833

Purchase Order Date 4/8/2011

PO Print Date 4/8/2011

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

613 678 3957

613 678 3956

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CL 11/10/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-3P	LUG	4/15/2011 Yes	100.00 Ench	Dart Truck	\$13.6000	\$1,360.00

Mc 25 6/11/10

Special Inst: MACHINE AS PER DWG D2230 REV G
B65050

PO Total:

\$1,360.00



Change Nbr: 1

Change Date: 4/8/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

25

D2230-3

Mounting Lug


13833

8
16/4/26

MATERIAL: supplied by DART D2423 B63005

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shig Walz

Vankleek Hill, April 19, 2011



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17917
Date: Apr 19, 2011
Page 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13833	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug Material supplied by DART: D2423 B63005 8 11/04/26	Each	100	25	75
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				

Received by _____

Thank you for your order!